Bate: User: Friday, 24/10/2008 12:55:40 PM

Julie Dawson

**Process Sheet** 

Customer Job Number

This Issue

Prsht Rev.

First Issue

**Previous Run** 

: CU-DAR001 Dart Helicopters Services

S.O. No.

Type

: 42937

**Estimate Number** 

: 10310

P.O. Number

: 24/10/2008

: NC

: // : 39082

**Part Number** 

**Drawing Name** 

: D26175

**Drawing Number** 

: D2617 REV D2

: 31/10/2008

: N/A

: D2

: BUSHING

**Project Number** 

**Drawing Revision** 

**Material** 

**Due Date** 

Qty:

50 Um:

Each

Written By Checked & Approved By

Comment

04.07.14 : Est H

Reformat; added step 5 KJ/JLM

: MACHINED PARTS

**Additional Product** 

Job Number:

Seq. #:

1.0

**Machine Or Operation:** 

Description:

M6061T6T0500W058

6061-T6 RD Tube .500 x.058W



Comment: Qty.:

0.0205 f(s)/Unit

1.0238 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Total:

Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058)

Batch M 109/10

2.0

HARDINGE CNC LATHE SMALL







Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

QC2

3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK

Comment: SECOND CHECK

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



08/10/30



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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Da					e:		
		esolution:	Disposition:				QA: N/C Closed: [					
NCR:		,	WORK ORD	ER NON-CONFOR	MANCE	(NCR	)					
DATE	OTED	Description of NC			Section B			cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio	on	Sign & Date		ion C	Chief Eng	QC Inspecto		
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		<u></u>			<del> </del>							

Friday, 24/10/2008 12:55:40 PM Date: Julie Dawson User: **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Job Number: 42937 Part Number: D26175 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 **Comment: INSPECT ALODINE** PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W/O:	•		WO	RK ORDER CHAI	NGES			· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Categ	NCR	: Yes N	lo DQA	\:	Date:		
		esolution:	n: Disposition:				QA: N/C Closed:			
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DATE	STEP	Description of NC			Section B			ation	Approval	Approval QC Inspector
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DART AEROSPACE LTD	Work Order: 43937
Description: Bushing	Part Number: D2617-5
Inspection Dwg: D2617 Rev: D2	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

	X	X First Article			otype	•		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
0.223	+0.000/-0.010	.2225	//					
0.500	+/-0.010	~200)						
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Measured by:	43	Audited by:	JL	Prototype Approval:	N/A
Date: G(\0	128	Date:	08/0/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.09	New Issue	KJ/JLM	
В	06.03.08	Dwg Rev change	KJ/JLM 140	
С	08.01.16	Tolerance revised for 0.500 dimension	KJ/EC/DD	- ZZ

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQA</b> :	o DQA: Date:					
	Res	solution:	Disposition	n:	QA: N/C C	QA: N/C Closed: Date:						
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DATE	STEP	Description of NC			ection B	Verificat	tion	Approval	Approval			
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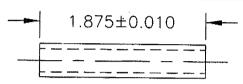


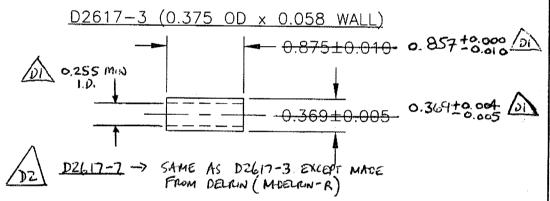
DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		_
CHEC	KED #	APPROVED	DRAWING NO. D2617 SHEET	REV. (	_
DATE			TITLE	SCAL	Ē
01.0	7.04		BUSHING	1:	1
Α		96.10.08	NEW ISSUE		_

DZ 04.04.10 #CD ADD 02617-7

В 97.05.08 .875 WAS 1,125 C 97.06.04 0.369 DIA WAS 0.375 D 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE 04.07.12 CORRECT TOLERANCE (NCR 779)

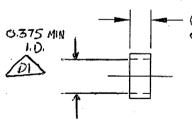
D2617 - 1.058 WALL`





D2617-5 (0.500 OD x 0.058 WALL)





<del>235±0.010</del>-0.223 +0.000

SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

NOTES:

1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)

OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)

BREAK ALL SHARP EDGES 0.005 TO 0.010

3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES									
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	٨:	_ Date: _			
	Re	esolution:	Disposition	_ QA: N/C CI	QA: N/C Closed: Date:						
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DATE	STED	Description of NC		on B	Verific	ation	Approval	Approval			
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector		
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